

# Work Order ID 65773

Tuesday, January 25, 2011 10:43:14 AM



Page 1

Item ID: D3821-1KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel w/o Rotor Brake-Ivory

Start Date: 1/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 1-01-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

*Handwritten initials*  
11/01/28

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x2

*Handwritten initials*  
11/01/28

Temp: 150°F

Time IN: 4:00 pm 11/01/27

Time OUT: 7:00 am 11/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Start Date: 1/25/2011 Start Qty: 2.00



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Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform Thermoforming Machine	0.00 0.00							
	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA023 using tool DT9053 Dwg Rev: <u>B</u> Folio Rev: <u>B</u>					x2			OK 11/01/08
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00				x2			OK 11/01/08
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				(x2)			B 11/02/03

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3821-1KIV

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Revision ID:

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Item Name: Panel w/o Rotor Brake-Ivory

Start Date: 1/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 		0.00							
HandThermo	Memo	0.00				x2			DL
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								11/02/01
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							DL
Quality Control	Complete FAI document								11/02/02
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							Subelos
Quality Control						(+2)			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 65773**

Tuesday, January 25, 2011 10:43:14 AM



Page 4

Item ID: D3821-1KIV

Accept



Setup Start



Revision ID:

Item Name: Panel w/o Rotor Brake-Ivory

Stop



Start Date: 1/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

11/2/ESF 20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08 MF 11-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, January 25, 2011 10:43:20 AM

Page 1

Work Order ID: 65773

Parent Item: D3821-1KIV

Parent Item Name: Panel w/o Rotor Brake-Ivory

Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 2.00

Required Qty: 2.00

**Comments:**

IPP Rev. A New Issue DL

IPP Rev. B Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased		No		100	sf	1,245.189	12.79	25.70854			



6185 KYDEX .080"



Location

therm

Loc Qty

1245.189115

101.189115

1144

Loc Code

109703

116576

Pl ✓  
11/02/03

25.70854 sg lt

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	65773
Description: Panel, without Rotor Brake		Part Number:	D3821-1KIV/KGY
Inspection Dwg: D3821	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching:	✓			

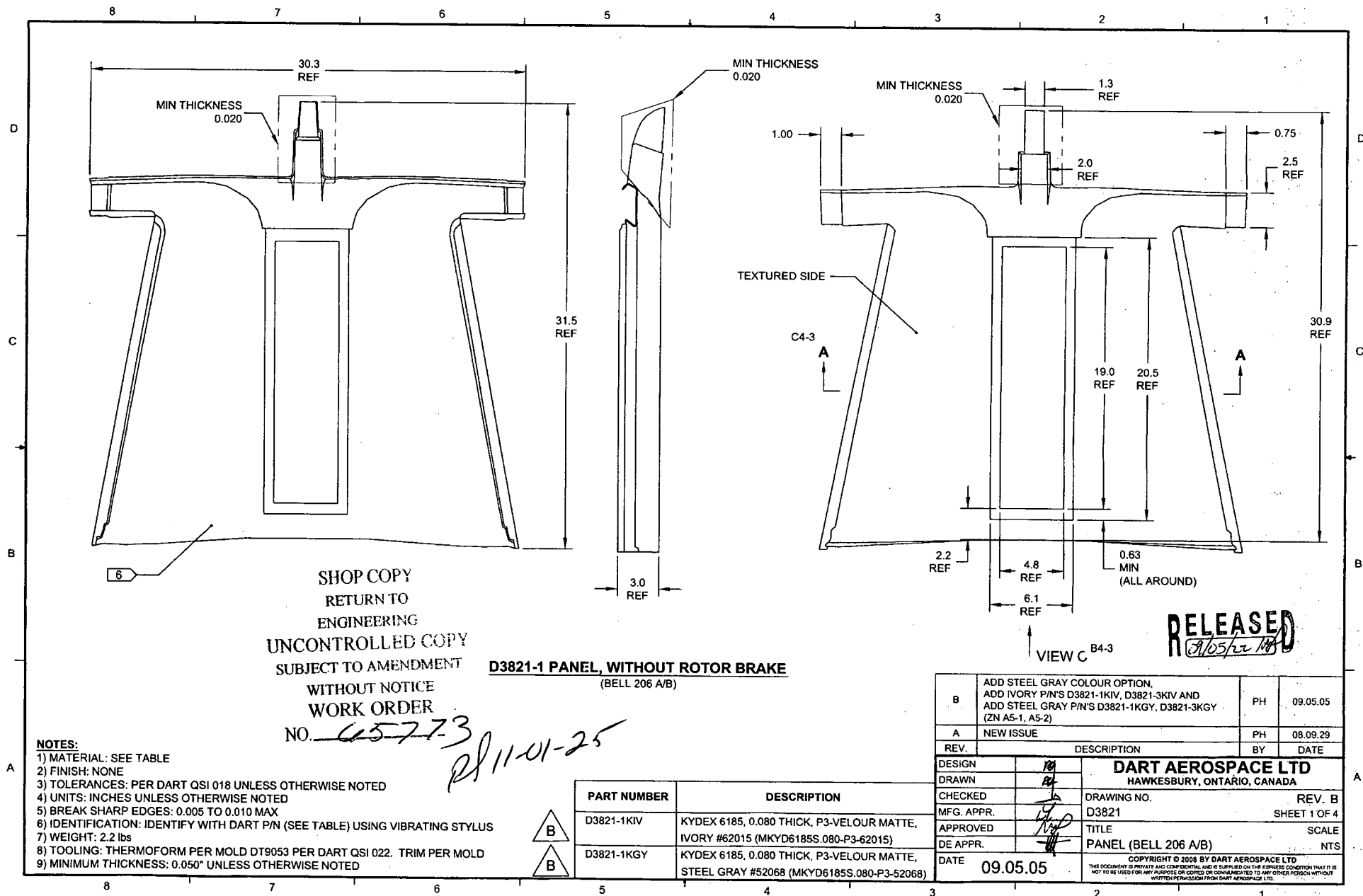
Measured by: DL Date: 11/01/08

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min	1.00"	✓			
0.75	Min	0.80"	✓			
0.63	Min	0.75"	✓			
0.25	Min	0.26"	✓			
0.375	Min	0.44"	✓			

Measured by: DL Date: 11/02/08  
 Audited by: B Date: 11/02/08  
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>DL</u>



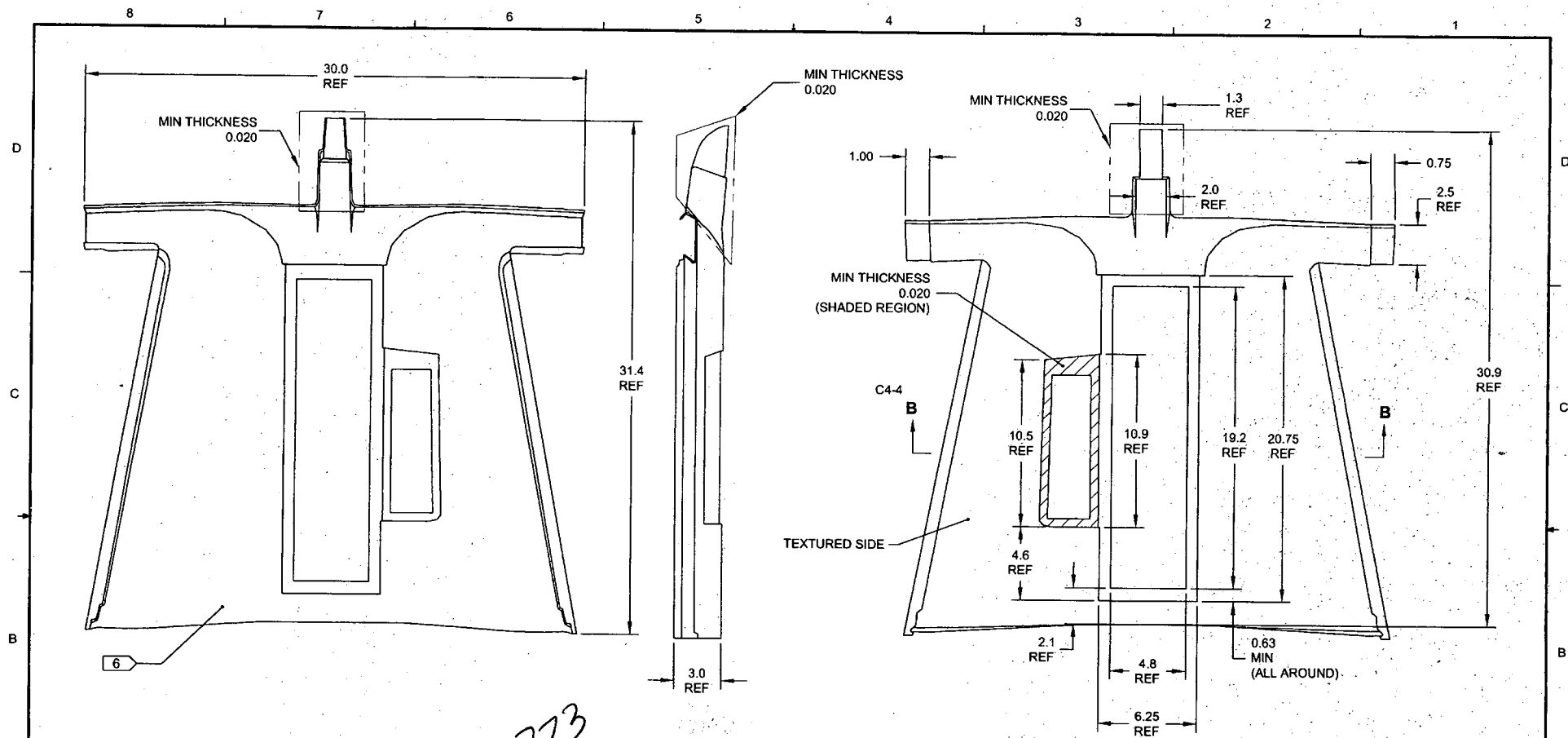
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**D3821-3 PANEL, WITH ROTOR BRAKE**  
(BELL 206 A/B)

VIEW D B4-4

**RELEASED**  
09/05/22

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9054 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3821-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3821
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 4
DE APPR.		TITLE SCALE
DATE	09.05.05	PANEL (BELL 206 A/B) NTS

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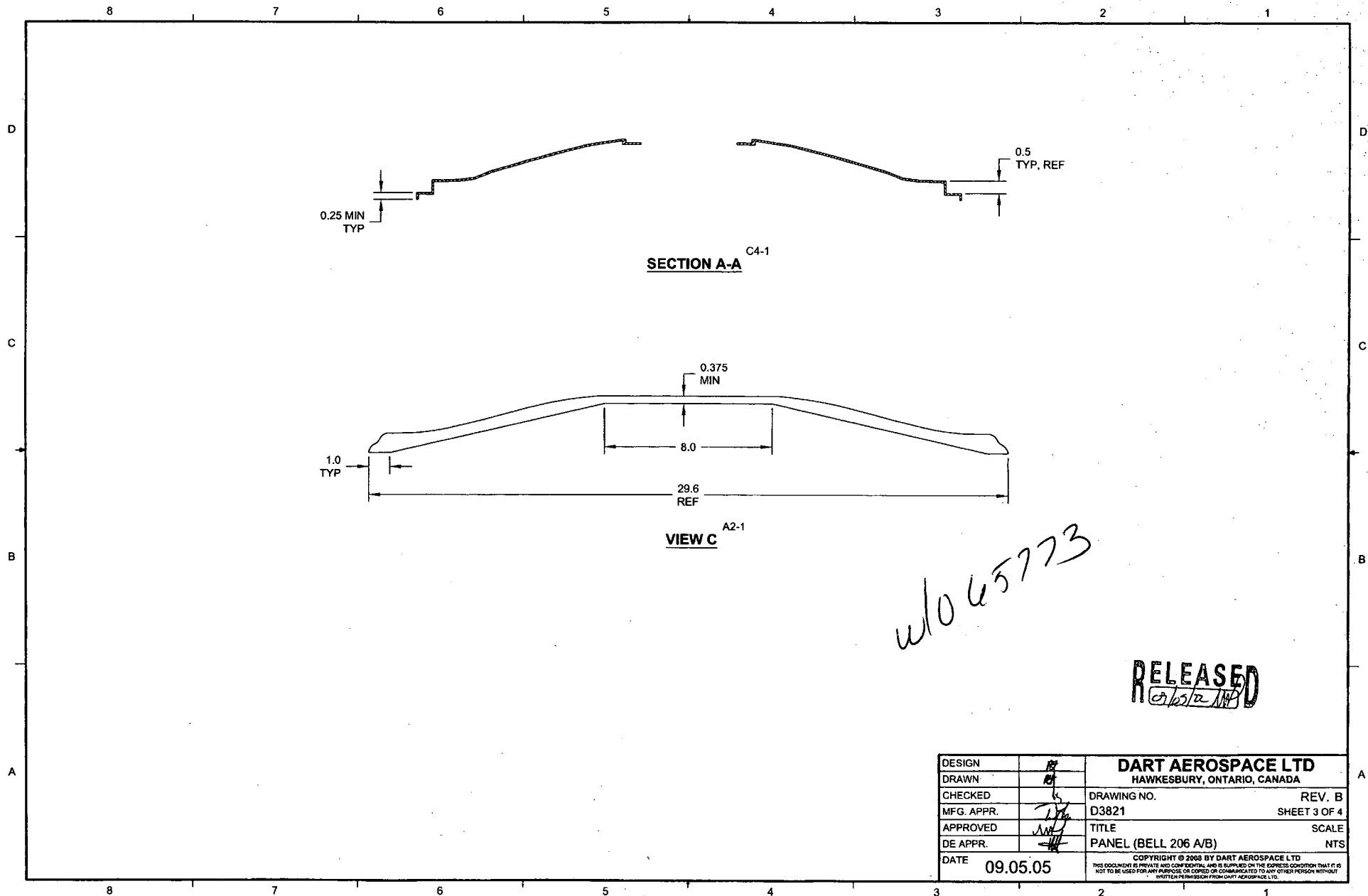
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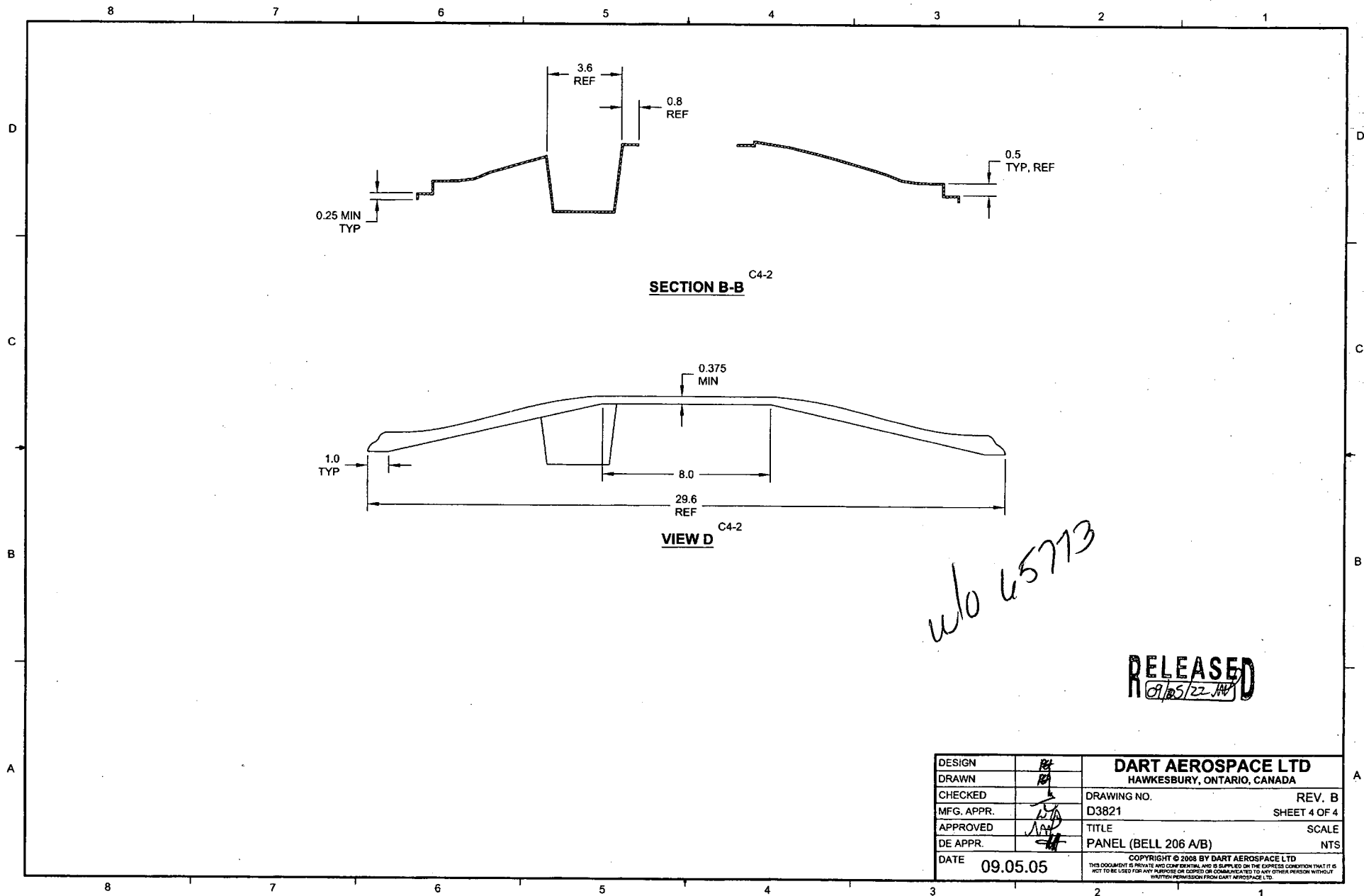
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**RELEASED**  
09/25/22

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3821	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (BELL 206 A/B)	NTS
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